

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017168**Date Inspected:** 23-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

Bay #19

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Bike Path 010. The weld designation reviewed is as follows:

BK004A6-010-076,082,096,102,080,100,078,098,072,073

BK004A5-010-003,005,008

BK004A3-010-058,059

BK004A2-010-001,011,012

BK004A4-010-021,022,047,048

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Bike Path 012. The weld designation reviewed is as follows:

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BK004A8-012-076,096,102,082,100,078,098,072,073
BK004A5-012-003,008,005
BK004A3-012-058,059
BK004A2-012-009,010
BK004A4-012-021,022

Visual Testing:-

This QA inspector performed random visual testing of the area previously tested and accepted by ZPMC Quality Control Personnel. The member is identified as Bike Path 010 and 012. The weld designation reviewed is as follows:

BK004A6-010-004,006,009,011,003,005,008,010,025,027,037,039
BK004A8-010-004,006,009,011,025,027,037,039
BK004A3-012-065,100,067,101,068,102,069,103,070,104,071,105
BK004A4-012-080,100,083,102,082,101,085,103,086,104,087,105

In process Inspection

Bay #19

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the Bike Path Stringer Plate, weld No: BK005A2-002-066/067. The welder is identified as #062738. ZPMC CWI is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2132. Please see the attached picture.

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the Bike Path, weld No: BK004A3-007-021. The welder is identified as #062764. ZPMC CWI is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

This QA Inspector observed the following work in progress:

FCAW in the 3F position for the Bike Path, weld No: BK004A3-006-043/044. The welder is identified as #062755. ZPMC CWI is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the Suspender Bracket, weld No: SB017-086-005. The welder is identified as #062786. ABF QA is identified as Mr. Peng Wen jun. The welding variables recorded by QC appear to comply with WPS-B-T-2232-TC-U4b-F.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the Suspender Bracket, weld No: SB017-090-001. The welder is identified as #062761. ABF QA is identified as Mr. Peng Wen jun. The welding variables recorded by QC appear to comply

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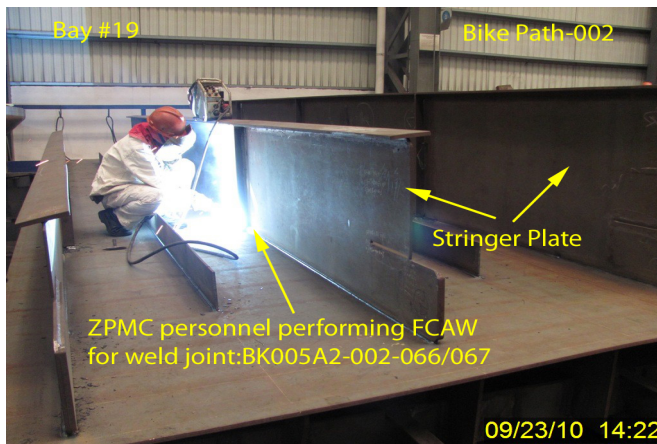
with WPS-B-T-2232-TC-U4b-F. Please see the attached picture.

Visual Inspection after Blast

Segment 11CW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Interior components of the Side panels and Bottom panel at Panel point 102 and 103 of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai, Pandaram	Quality Assurance Inspector
Reviewed By:	McClendon, Timothy	QA Reviewer
